

**Work Order ID 68026**

Tuesday, April 05, 2011 1:14:52 PM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/04/05

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3264	Rev A2

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 5.700" LONG

0.00

CL 11/04/06

10 ✓

A.A 11/04/11

1 ✓

110



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOILIO FA447  
FOLIO REV: AA  
DWG REV: A

0.00

A.A 11/04/07

10 1

DEBURR AS PER DWG

Pb?

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3264-1 PAR #: N/A Fault Category: Machinery NCR: Yes No DQA: A Date: 11/04/21  
 11/04 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/04/25

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/11	110	1) part scrap due to a tool that scored the part .045" deep in floor area, during a tool change. R.C Machine tool change malfunction	11/04/12 OSI042	→ Dropped the Z origin by .045" the floor is ok but the .063" lip is no longer within tolerance SCRAP + REPLACE. B/N: 112428	M.A 11/04/11	✓ 11/04/12	11/04/12 OSI042.	S 11/04/18

NOTE: Date & initial all entries

**Work Order ID 68026**

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Item ID: D3264-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 11/04/07

10

1

QC

Quality Control

130



QC8- Inspect parts - second check

0.00

DK 11/04/12

10

8

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

10

BR 11-4-13

HandFinish

Hand Finishing

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 68026**

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Item ID: D3264-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



Powdercoat

Powder Coating

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  
**M116946**  
 Memo      *START 3:55*  
*OUT 320 0.00*  
*FINISH 4:25*

*10 BL 11-4-13.*

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

*10 BL 11-04-14*

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

0.00

Memo

0.00

*11/14/14 SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 68026**

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Item ID: D3264-1

Accept



Setup

Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

180



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

0.00

11/4/18 JJ

MK  
11-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, April 05, 2011 1:14:49 PM

Page 1

Work Order ID: 68026



Parent Item: D3264-1



Parent Item Name: Bracket

Start Date: 4/5/2011

Required Date: 4/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A□04.09.02□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased		No			f	17.0000		5			

6061-T6 Bar 1.25 X 4.50



Location	Loc Qty	Loc Code
MAT004	17	
112628	17	

5 mkl 11/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68026
Description: Bracket	Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.690	✓		Vern	GA-01
0.063	+/-0.010	0.063	✓		"	"
0.125	+/-0.010	0.124	✓		"	"
0.875	+0.010/-0.020	0.875	✓		"	"
0.062	+/-0.010	0.062	✓		"	"
R0.03	+/-0.030	R0.032	✓		R-G	ref.
R0.13	+/-0.030	R0.125	✓		"	"
1.00	+/-0.030	1.001	✓		Vern	GA-01
0.125	+/-0.010	0.125	✓		"	"
0.600	+/-0.010	0.600	✓		"	"
4.000	+/-0.005	4.000	✓		"	"
0.750	+/-0.010	0.749	✓		"	"
Ø0.194	+0.005/-0.000	Ø0.197	✓		"	"
5.50	+/-0.030	5.500	✓		"	"
0.125	+/-0.010	0.125	✓		"	"
0.063	+/-0.010	0.065	✓		M/c	118-120
R0.25	+/-0.030	R0.250	✓		R-G	ref.
4.27	+/-0.030	4.270	✓		Vern	GA-01
R0.30	+/-0.030	R0.300	✓		R-G	ref.

Measured by:	J.A	Audited by:	ony	Prototype Approval:	N/A
Date:	11/04/07	Date:	11/04/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	JK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

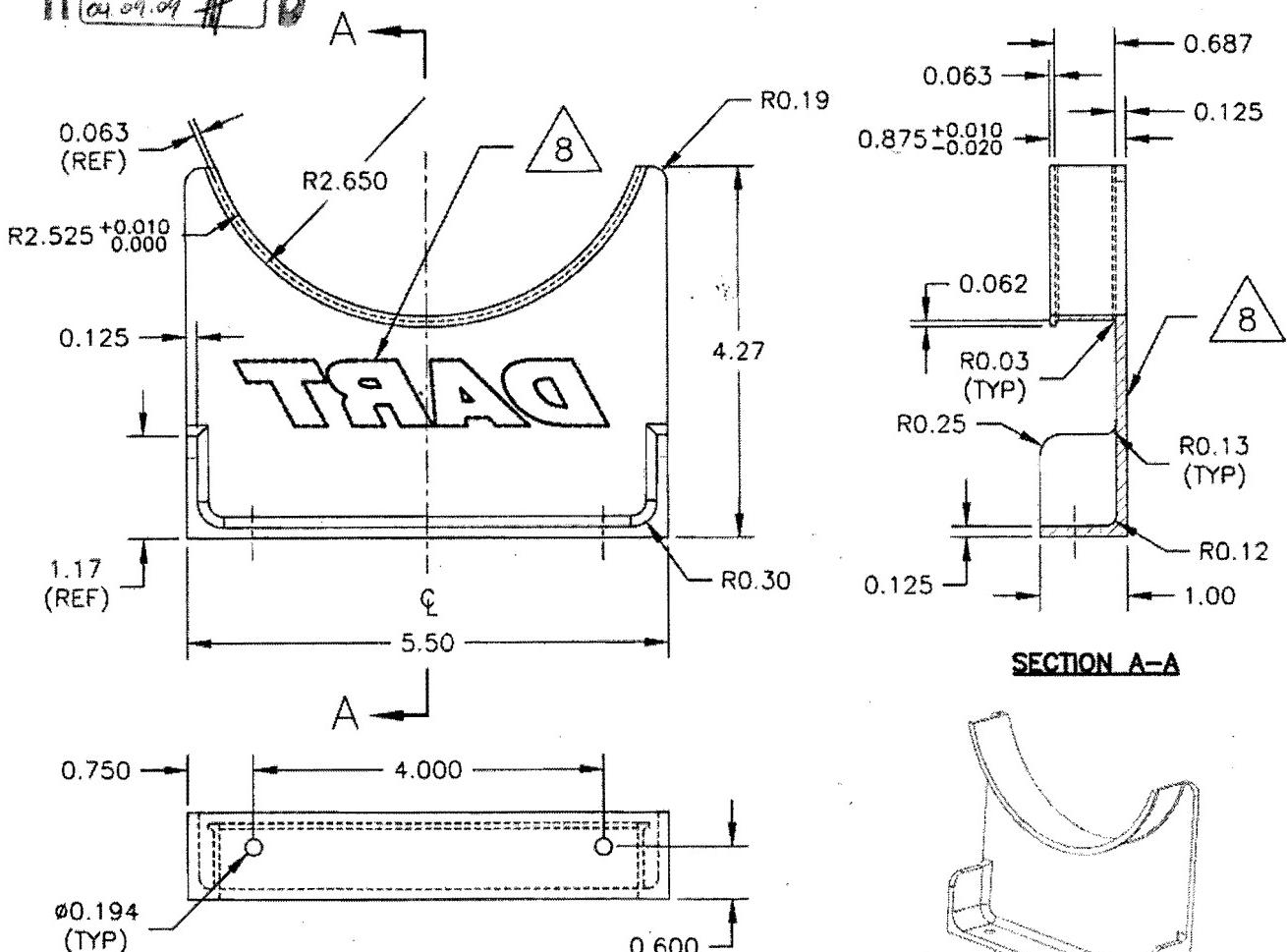
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

**RELEASED**  
04.04.09 *[initials]***D3264-1 BRACKET****D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH  
(MIN) TOOL RADIUS OF 0.25

*CD 11104/05**W/D: 6/2026*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries